

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 73849

Friday, September 16, 2011 12:47:48 PM

Page 2

Item ID: D2662-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Saddle, LH In 206					
Start Date: 9/16/2011	Start Qty: 10.00		Cust Item ID:		
Required Date: 11/4/2011	Req'd Qty: 10.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		mk 11/09/27		10	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10 COUNT	0		11/09/27
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							10X0 M-11/09/28

START TIME: 9:10 DOVEN TEMPERATURE:
FINISH TIME: 320°F 9:40

M118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73849

Friday, September 16, 2011 12:47:48 PM



Page 3

Item ID: D2662-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH In 206

Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

10x / 10/10/28

170 Identify as per dwg & Stock Location ~~ST 435~~ 0.00



Packaging Memo 0.00

Packaging

SP

10x SP 11-09-28

180 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

11/10/3 MF 11-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 12:47:46 PM

Page 1

Work Order ID: 73849

Parent Item: D2662-1

Parent Item Name: Saddle, LH In 206



Start Date: 9/16/2011

Required Date: 11/4/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C 00.06.22 Removed P/O for powder coat EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	49.0000	1	10			

Saddle Billet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	49	
64777	20	
66965	1	
69677	2	
70976	10	
72225	16	

→ 73768

10.0

B.A 11/09/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 73849
Description: 206 Saddle, Inboard, Left side	Part Number: D2662-1
Inspection Dwg: D2662 Rev. D	Page 1 of 2

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140	Da .02	.115	.115	.115	.115	.115	
B	0.100	0.140	Da .05	.137	.137	.137	.137	.137	
C	1.125	1.145		1.140	1.140	1.140	1.140	1.140	
D	0.615	0.685		.685	.685	.685	.685	.685	
E	0.240	0.260		.246	.246	.246	.246	.246	
F	1.313	1.343		1.324	1.324	1.324	1.324	1.324	
G	0.210	0.230		.220	.220	.220	.220	.220	
H	0.100	0.180		.118	.118	.118	.118	.118	
I	2.470	2.510		2.493	2.493	2.493	2.493	2.493	
J	1.565	1.585		1.580	1.580	1.580	1.580	1.580	
K	0.235	0.240		.239	.239	.239	.239	.239	
L	0.100	0.120		.108	.108	.108	.108	.108	
M	0.990	1.010		.991	.991	.991	.991	.991	
N	0.510	0.515		.512	.512	.512	.512	.512	
O	5.990	6.010		6.002	6.002	6.002	6.002	6.002	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.315	.315	.315	.315	.315	
S	0.315	0.322		.315	.315	.315	.315	.315	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.363	1.363	1.363	1.363	1.363	
V	0.787	0.807		.796	.796	.796	.796	.796	
W	0.540	0.560		.551	.551	.551	.551	.551	
X	1.674	1.684		1.680	1.680	1.680	1.680	1.680	
Y	0.257	0.262		.257	.257	.257	.257	.257	
Z	0.912	0.932		.922	.922	.922	.922	.922	
AA	0.490	0.510		.497	.497	.497	.497	.497	
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>PR</i>
Date: <i>11.9.26</i>

Audited by: <i>OmR</i>
Date: <i>11/09/27</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 43849
Description: 206 Saddle, Inboard, Left side	Part Number: D2662-1
Inspection Dwg: D2662 Rev. D	Page 2 of 2

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#6	#7	#8	#9	10 BY	Date
A	0.100	0.140		0.110	0.112	0.112	0.114	0.112	Mic / GA-03
B	0.100	0.140		0.137	0.136	0.137	0.137	0.137	Mic / 11B-120
C	1.125	1.145		1.138	1.138	1.137	1.138	1.138	Dial / HAASZ
D	0.615	0.685		0.685	0.685	0.685	0.685	0.685	Vern / GA-01
E	0.240	0.260		0.246	0.246	0.246	0.246	0.246	" "
F	1.313	1.343		1.320	1.320	1.320	1.320	1.320	H-6 / 31006
G	0.210	0.230		0.216	0.217	0.217	0.217	0.218	Vern / GA-01
H	0.100	0.180		0.135	0.135	0.135	0.135	0.135	" "
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	" "
J	1.565	1.585		1.580	1.580	1.579	1.580	1.579	Dial / HAASZ
K	0.235	0.240		0.238	0.238	0.238	0.238	0.238	Vern / GA-01
L	0.100	0.120		0.110	0.110	0.110	0.110	0.110	D-6 / GA-03
M	0.990	1.010		0.992	0.992	0.992	0.992	0.992	Vern / GA-01
N	0.510	0.515		0.514	0.514	0.514	0.514	0.514	" "
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	" "
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	" "
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	" "
R	0.313	0.318		0.315	0.315	0.315	0.315	0.315	" "
S	0.315	0.322		0.317	0.317	0.317	0.317	0.317	" "
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	" "
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	" "
V	0.787	0.807		0.792	0.792	0.792	0.792	0.792	" "
W	0.540	0.560		0.550	0.550	0.550	0.550	0.550	" "
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	" "
Y	0.257	0.262		0.258	0.258	0.258	0.258	0.258	" "
Z	0.912	0.932		0.923	0.923	0.923	0.923	0.923	" "
AA	0.490	0.510		0.497	0.501	0.500	0.500	0.500	" "
AB	0.178	0.198		0.188	0.188	0.188	0.188	0.188	RG / ref.
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: BA
Date: 11/09/26

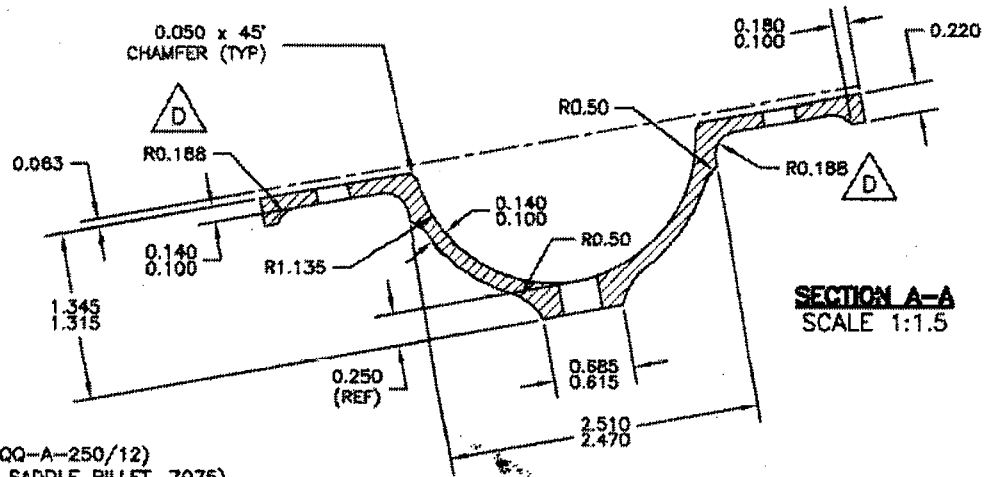
Audited by: <i>one</i>
Date: 11/09/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



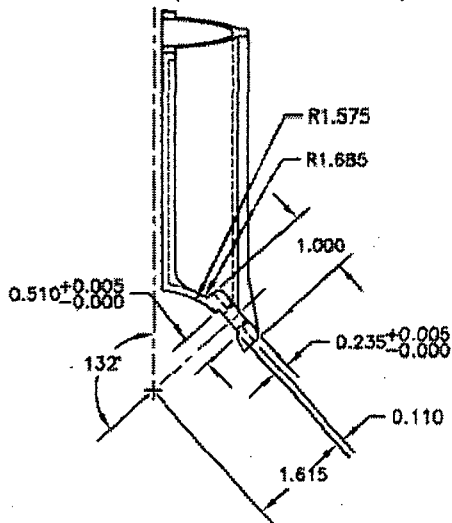
DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE INSIDE	SCALE 1:3	
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCPORP' DEO 9122/9102/9095/9137	
D	06.11.08	RO.188 WAS RO.30; Ø0.316 WAS Ø0.313	

RELEASED
07.02.12 #

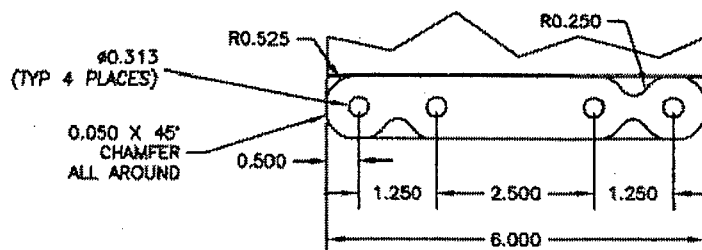
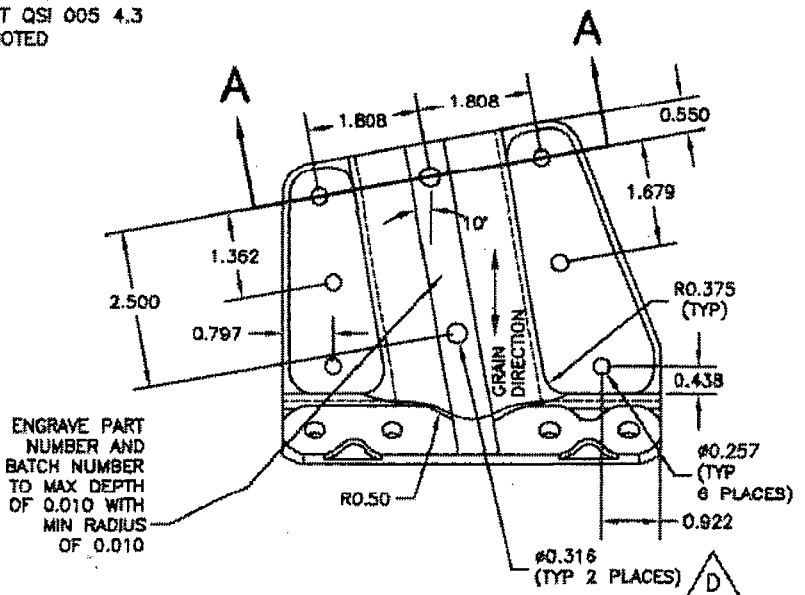


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)



D2662-1 SADDLE INSIDE



Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

